



Dart Aerospace Ltd.
1270 Aberdeen St
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D5407-043

Job Sheet 193263



Part No: D5407-043

Job Qty: 1 pcs

DAS
21

Part Name: Strut Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/9/19

Job Tracking No:

Due Date: 4/29/19

Created By: Dara Macdonald

Type: Stock

Description:

Note: DWG REV A SHEETS 2,5 IPP REV:A NEW ISSUE JLM 16.06.06 VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	1 pcs		4/29/19	0.00	0.19	Bandsaw - 1		ann L 19/6/19
110	HAAS 4 Axis - B4B	1 pcs		4/29/19	0.00	0.00	HAAS - 1 - B4B		ann L 19/6/19
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
120	QC 2	1 pcs		4/29/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		ann L 19/6/19
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		



Container No: S178854



Part: D5407-043

Job No: 193263

Serial No/Batch: S178854

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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CANADA
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Date: 05/08/19

130 QC 8	1 pcs	4/29/19	0.00 0.00	QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	1/18 19/5/19
140 Handfinish - 1-1 Chemical-B4B	1 pcs	4/29/19	0.00 0.41	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	D.R 19/05/10
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	

				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150 QC 7	1 pcs	4/29/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	BEB 19-05-10.
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
160 Powdercoat - 1 White GI(A)- B4B	1 pcs	4/29/19	0.00 0.03	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
START: 8:40 ACT: 300° FINISH: 9:10.					
170 QC 3	1 pcs	4/29/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
180 Small Fab - 2 - B4B	1 pcs	4/29/19	0.00 0.46	Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	

BEB 19-05-10.

BEB 19-05-10.

DAS
30
9-89

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190 QC 5	1 pcs	4/29/19	0.00 0.00	Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
200 Packaging 3-1 - Stock - B4B	1 pcs	4/29/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
210 QC 21 - SA	1 pcs	4/29/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 100 - (Bandsaw)

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Descriptions: 110 - 1-Machine per folio FB522 (D5407-3) DWG REV: _____ FOLIO REV: _____ 2- Deburr and break all sharp edge as per dwg.

120 - (QC2- Inspect parts off machine FAI/FAIB)

130 - (QC8- Inspect parts - second check)

140 - (Chemical Conversion Coat per QSI005 4.1)

150 - (QC7-Inspect Chemical Conversion Coat)

160 - START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____

170 - (QC3- Inspect Part Finish)

180 - ASSEMBLE AS PER DWG

190 - (QC5- Inspect part completeness to step on W/O)

200 - (Identify as per dwg & Stock Location: _____)

210 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.750X00.750	6061-T6 Bar .750 X .750	7.0650 ft (1.413 ea)	100-Bandsaw - 1	S172 189
AN3-12A	Bolt	5 Ea (1 ea)	180-Small Fab - 2 - B4B	S133 167
AN3-13A	Bolt	5 Ea (1 ea)	180-Small Fab - 2 - B4B	8098 082
D2690-6	Lanyard	10 pcs (2 ea)	180-Small Fab - 2 - B4B	1x176872-1x176322-2xS162805
D5406-1	Connector	10 pcs (2 ea)	180-Small Fab - 2 - B4B	8xS175271-2xS154828
MS17984-C408	Quick Release Pin	5 pcs (1 ea)	180-Small Fab - 2 - B4B	3050039
MS17984-C409	Pin, Quick Release	5 Ea (1 ea)	180-Small Fab - 2 - B4B	F1136866
MS21042L3	Nut	15 Ea (3 ea)	180-Small Fab - 2 - B4B	S204283
MS27039-1-20	Screw	5 Ea (1 ea)	180-Small Fab - 2 - B4B	S182 772
NAS1149D0363J	Washer	40 Ea (8 ea)	180-Small Fab - 2 - B4B	1xS1724055-39xS171831

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B0.750X00.750	7	27	0
180-Small Fab - 2 - B4B	AN3-12A	5	199	5

Allocated Container Detail

Qty	Container No	Location	Init
5	S206535	st349	_____
	AN3-13A	5	39
			5

Allocated Container Detail

Qty	Container No	Location	Init
5	S206537	st349	_____
	D2690-6	10	129
			10

Allocated Container Detail

Qty	Container No	Location	Init
1	S176872	st009	_____
1	S178507	st009	_____
1	S183791	st123	_____
2	S182805	st009	_____
5	S206552	st009	_____
	D5406-1	10	8
			8

Allocated Container Detail

Qty	Container No	Location	Init
8	S175271	st162	_____
	MS17984-C408	5	21
			5

Allocated Container Detail

Qty	Container No	Location	Init
5	S050039	st315	_____
	MS17984-C409	5	21
			5

Plex 8/19/19 8:52 AM dart.boivin.carole

